



Dart Aerospace Ltd.
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K6A 1K7
Canada

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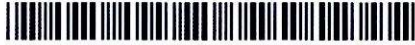
D3913-041
Job Sheet 212851



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/8/20

Job Tracking No:

Due Date: 10/16/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV:B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/15/20		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	10/15/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	10/15/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

CL 10-13-20

OCT 14 2020

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Container No: S306128



Part: D3913-041

Job No: 212851

Serial No/Batch: S306128

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/13/20

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					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
					QC 5 - 82		
125	Handfinish - 2-1 Pressure-B4B	1 pcs	10/15/20	0.00 0.29	Handfinish - 2 - 1 - B4B	20-10-15	DAS 34 9-89
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	10/15/20	0.00 0.93	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B	20-10-15	DAS 34 9-89
					Powdercoat - 4 - B4B		
					Powdercoat - 5 - B4B		
					Powdercoat - 6 - B4B		
					Powdercoat - 7 - B4B		
					Powdercoat - 8 - B4B		
					Powdercoat - 9 - B4B		
					Powdercoat - 10 - B4B		
140	QC 3	1 pcs	10/15/20	0.00 0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15	all 20-10-16	DAS 15 9-89
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
					QC 3 - 87		
					QC 3 - 47		
150	Handfinish - 4-1-Assembly-B4B	1 pcs	10/16/20	0.00 0.50	Handfinish - 4 - 1 - B4B	all 20-10-16	
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 -		

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				B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 5	1 pcs	10/16/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
170 Packaging 3-1 - Stock - B4B	1 pcs	10/16/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	

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					Packaging 3 - 15 - B4B	Jul 20-10-16
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	1 pcs	10/16/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 9	9-89
					QC 21 - SA - 77	
					QC 21 - SA - 28	
Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg						
110 - QC9- Inspect visual per QSI004- Fusion Welds						
120 - QC5- Inspect part completeness to step on W/O						
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings						
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat						
140 - QC3- Inspect Part Finish						
150 - Assemble as per dwg - Pick Kit						
160 - QC5- Inspect part completeness to step on W/O						
170 - Identify as per dwg & Stock Location: _____						
180 - QC21- Final Inspection - Work Order Release						

017694

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	\$291266
D3913-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	\$266446
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	\$267768
D3913-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	\$266451
D3913-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	\$255994
D3913-9 ✓	Hinge Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	\$266454
D3916-041 ✓	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	\$304808
D3916-5 ✓	Light Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	\$297570
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	\$257681
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	\$248314
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	\$302525
D4020-11 ✓	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	\$305756
D4021-1 ✓	Handle Plate	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	\$253605
D4034-041 ✓	Aft Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	\$302679
D4034-043 ✓	Fwd Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	\$302829
D4672-1 ✓	Blanking Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	\$259507
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	\$256752
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	\$763416-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	\$23535
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	\$304836
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	\$816387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	\$366483
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	\$136360

Job Allocations

017776

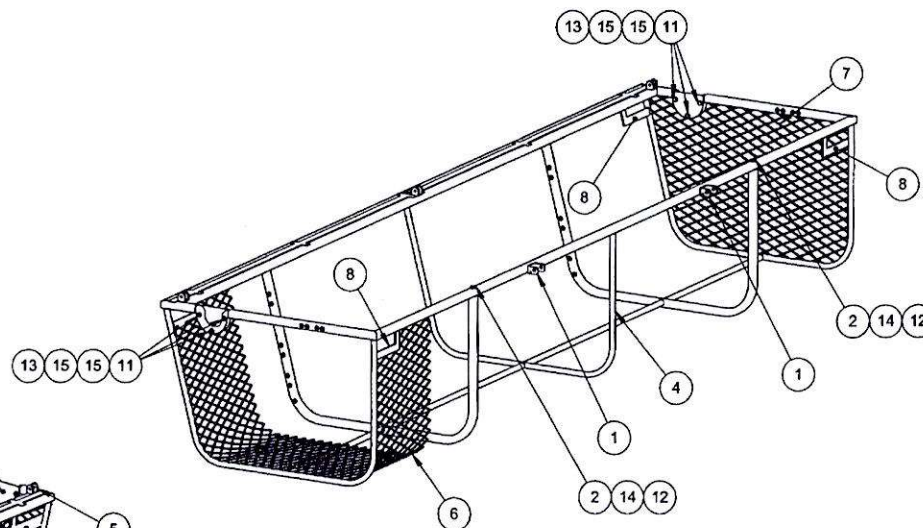
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	34	0
	D3913-1	1	5	0
	D3913-15	1	19	0
	D3913-3	1	5	0
	D3913-7	2	10	0
	D3913-9	1	6	0
	D3916-041	2	6	0
	D3916-5	3	12	0
	D4016-1	3	27	0
	D4017-7	3	42	0
	D4017-9	2	4	0
	D4020-11	2	6	0
	D4021-1	3	15	0
	D4034-041	1	3	0
	D4034-043	1	3	0
	D4672-1	2	32	0
	M304EX0.75-16F	32	790	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	154	0
	D2931	2	455	0
	D4021-5	2	6	0
	MS20600-AD4W3	2	294	0
	MS21042L3	6	819	0
	NAS1149F0332P	12	2,114	0
	NAS1149FN832P	2	1,868	0

Part Specifications

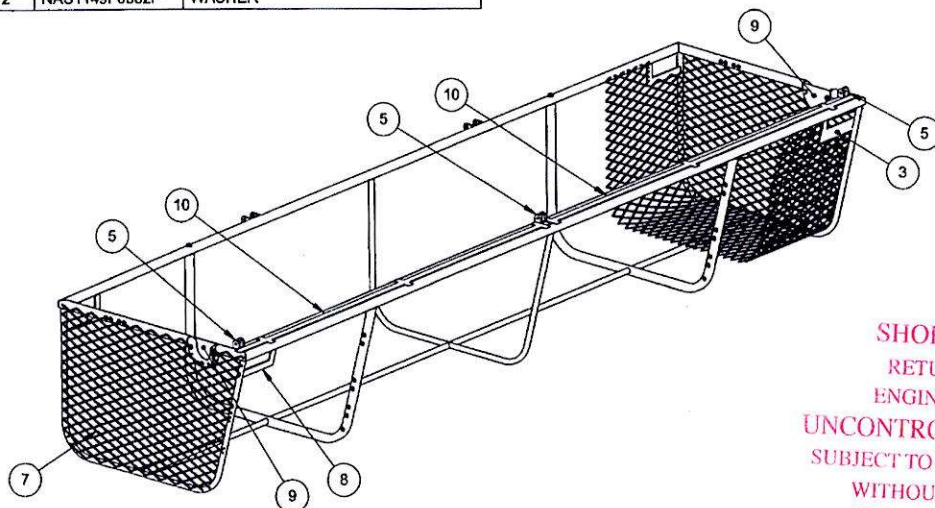
Specifications could not be found.

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212851

NOTES:

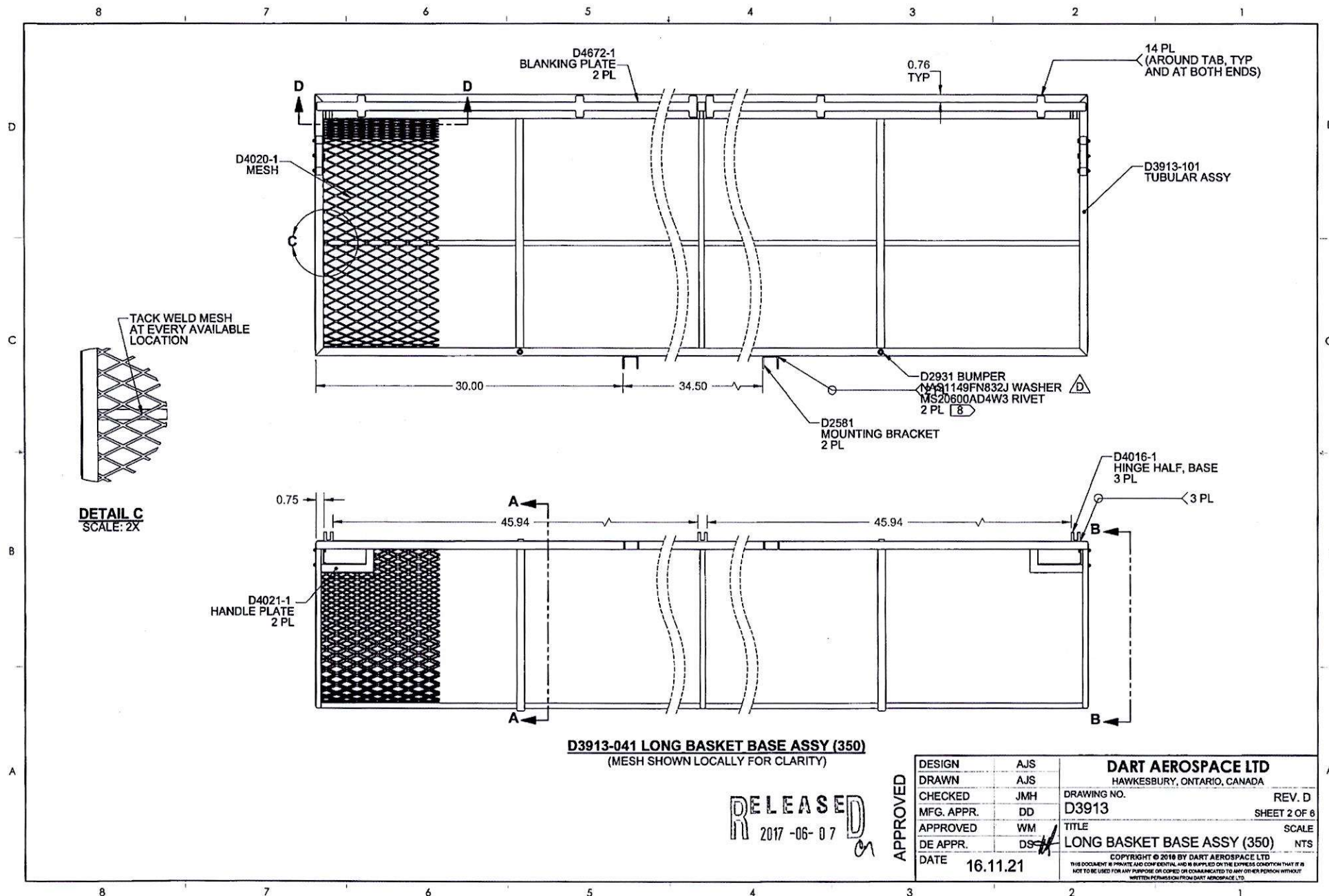
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

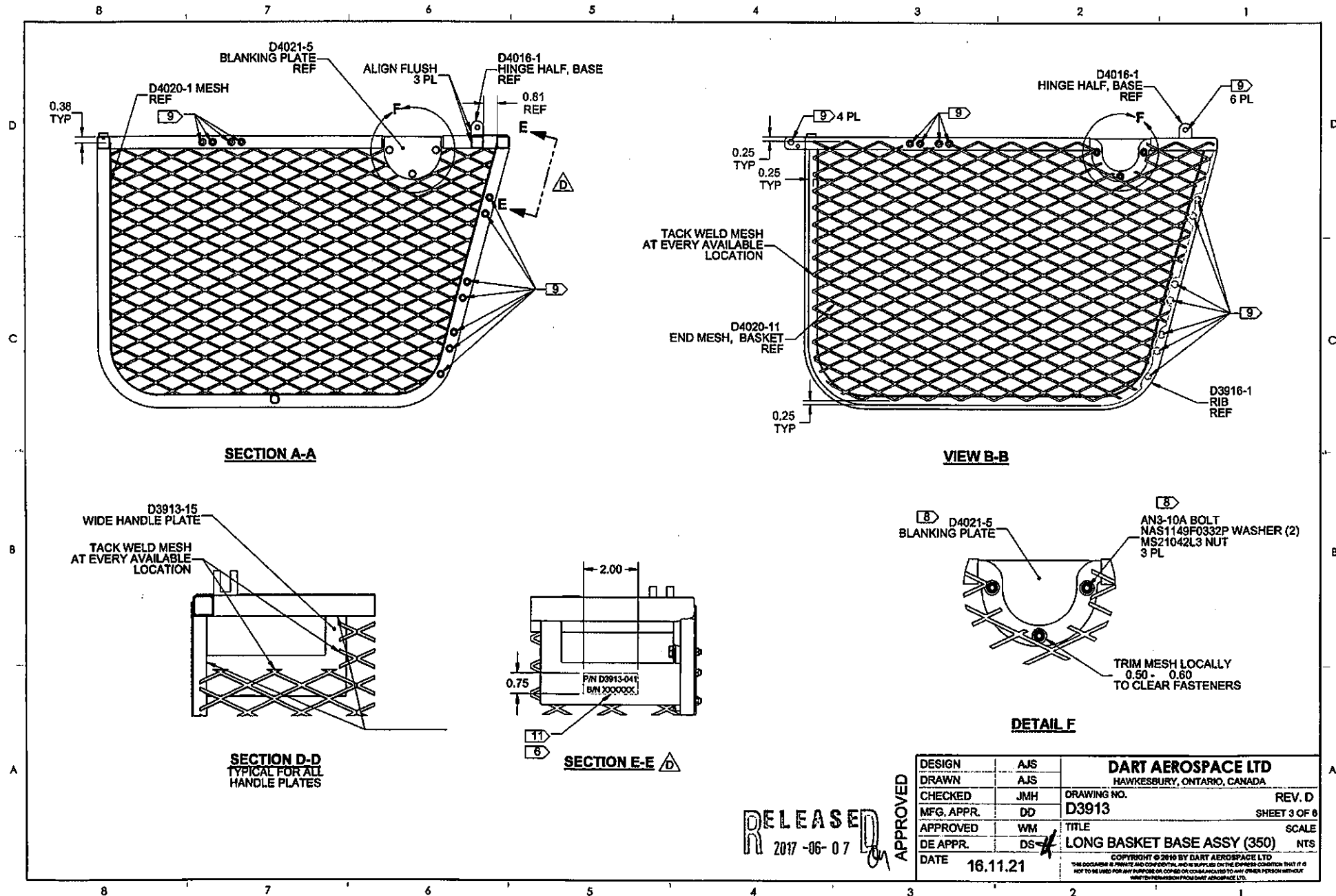


RELEASED
2017-06-07
CAN 17-580

APPROVED

D	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN960JDB, UPDATED NOTE 8, ADDED NOTE 11. SHEET 3 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 REV. D SHEET 1 OF 6 TITLE LONG BASKET BASE ASSY (350) SCALE NTS COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AJS		
CHECKED	JMH		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	D3-11		
DATE	16.11.21		





RELEASED
2017-06-07

APPROVED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					